

# Work Order ID 73937

Wednesday, September 21, 2011 3:50:17 PM



Page 1

Item ID: D205-765-011

Accept



Setup Start



Revision ID:

Item Name: Driveshaft Tunnel

Stop



Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/21/2011 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA111270

Approvals: Process Plan: *MF*

Date: *11-09-21*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D205-765

Rev A

100

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

INSPECT RA 111270

D205-765-011 B 545 *17 CHG001*

*8 11/09/11*

*(70)*

UPON INSPECTION :

D3648-041 HAS DAMAGE ON IT

NEEDS TO BE REWORKED

KIT IS COMPLETE

110

0.00



Small Fab

Memo

0.00

Small Fab

REWORK TO DRAWING D3648-041 TO CORRECT DAMAGE

*SB 11/09/11*

*(9)*



**Work Order ID 73937**

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Wednesday, September 21, 2011 3:50:17 PM

Item ID: D205-765-011

Accept



Setup Start



Revision ID:

Item Name: Driveshaft Tunnel

Stop



Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/21/2011 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA111270

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

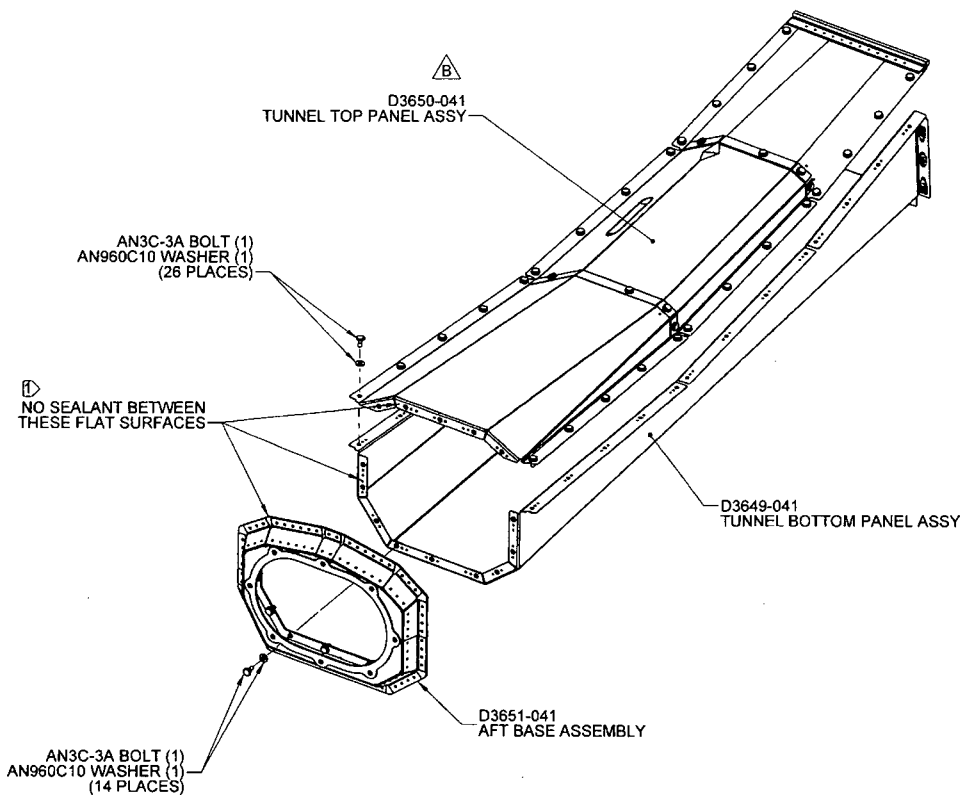
Memo

0.00

Quality Control

11/9/28

MF  
11-09-27



**D3648-041 DRIVE SHAFT TUNNEL ASSEMBLY**

**NOTES:**

- 1) SEAL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT EXCEPT WHERE NOTED
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3648-041 USING FINE POINT PERMANENT INK MARKER
- 7) TORQUE FASTENERS TO 15-25 in-lb
- 8) WEIGHT: 9.2 lbs



**PART LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D3648-041	DRIVE SHAFT TUNNEL ASSEMBLY
1	D3649-041	TUNNEL BOTTOM PANEL ASSEMBLY
1	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3651-041	AFT BASE ASSEMBLY
40	AN3C-3A	BOLT
40	AN960C10	WASHER

RELEASED  
08-03-27/10

B	UPDATE WITH REVISED D3650-041	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	IE	DRAWING NO.	REV. B
MFG. APPR.	WMP	D3648	SHEET 1 OF 1
APPROVED	WMP	TITLE	SCALE
DE APPR.	WMP	DRIVE SHAFT TUNNEL ASSY	1:8
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

# Work Order ID 54517

December 10, 2009 2:43:51 PM



Page 1

Item ID: D205-765-011

Revision ID:

Item Name: Driveshaft Tunnel

Start Date: 12/10/09 Start Qty: 3.00

Required Date: 12/11/09 Req'd Qty: 3.00

Reference:

Approvals: Process Plan: *W*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN D205-765

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPd205-765

CHG 001

*S 01/12/14*

*H for BG 09/12/10*

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*9/12/11 (3+) SP*

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*=> S 01/12/14*

*(B) /*

# Work Order ID 54517

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Page 2

Item ID: D205-765-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Driveshaft Tunnel

Start Date: 12/10/09 Start Qty: 3.00



Cust Item ID:

Required Date: 12/11/09 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw Draw Plan Accept Reject Reject Insp.  
Number Rev. Code Qty Qty Number Stamp

130



Packaging

Packaging

0.00

Memo

0.00

PACKAGE PER PPP

B

10/12/14 (3)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/12/17

W01215

# Picklist Print

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Page 1

Work Order ID: 54517

Parent Item: D205-765-011

Parent Item Name: Driveshaft Tunnel

Comments:

Start Date: 12/10/09

Required Date: 12/11/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C3A Bolt	217	Purchased	No			110	Each	681.0000	51.0000	9/10/11	sp	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

681

110715

50

110916

431

113359

200

Purchased

No

110

Each

180.0000

51.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

180

111965

180

Manufactured

No

110

Each

0.0000

3.0000

D3648-041

Driveshaft Tunnel Assembly

D3654-1

Doubler

Manufactured

No

110

Each

2.0000

3.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

44678

2

51X

9/10/11 sp  
M113422 15x 9/10/14 sp

36x 52  
9/10/11 53836 53837

9/12/11 sp  
B54521 (12) sp

2X

# Picklist Print

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Work Order ID: 54517

Parent Item: D205-765-011

Parent Item Name: Driveshaft Tunnel

Comments:

Start Date: 12/10/09

Required Date: 12/11/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3682-1 Gasket		Manufactured	No			110	Each	13.0000	3.0000		9/12/11	(34)

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

13

43924

1

44680

12

3

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Shop Packet Print

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## 5. PARTS LIST

Qty	Part Number	Description
X	D205-765-011	DRIVESHAFT TUNNEL KIT
1	D3648-041	TUNNEL ASSEMBLY
1	*D3649-041	TUNNEL BOTTOM PANEL ASSY.
1	**D3649-1	TUNNEL BOTTOM PANEL
22	**MS21060-3K	NUTPLATE
22	**MS21062-3K	NUTPLATE
88	**MS20427M3-3	RIVET
1	*D3650-041	TUNNEL TOP PANEL ASSY.
1	**D3650-1	AFT PANEL
1	**D3650-3	CENTER PANEL
1	**D3650-5	FWD PANEL
8	**AN3C-3A	BOLT
8	**AN960C10	WASHER
1	*D3651-041	AFT BASE ASSEMBLY
1	**D3651-043	FLANGE WELDMENT
1	**D3651-1	GASKET
1	**D3651-9	INSIDE DOUBLER
1	**D3651-11	GASKET
1	**D3651-13	OUTSIDE DOUBLER
58	**CR3523-4-02	RIVET
40	*AN3C-3A	BOLT
40	*AN960C10	WASHER
1	*D3654-1	DOUBLER
1	D3682-1	GASKET
17	AN3C-3A	BOLT
17	AN960C10	WASHER
A/R	MS20427M4	RIVET

\* PART IS INCLUDED WITH D3648-041 TUNNEL ASSEMBLY

\*\* PART IS INCLUDED WITH ASSEMBLY ABOVE

54517